

Work Order ID 87800

87800

Page 1

July-12-12 10:00:11 AM

Item ID: D2966-1-BENT

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Assembly 105

Start Date: 12/07/2012 Start Qty: 1.00

Required Date: 17/07/2012 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

1
1
ZDP
12-7-31

Approvals: Process Plan: M-L-J

Date: 12/07/12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2966

Rev A

120

0.00

120

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

2- Cut Fwd end of the tube using DT8185-1
1- Bend tube as per program BO105 on CNC Bender and Dwg D2966. Bend
folio #1 use bending aid DT9631

7 DC 12/07/31

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control



Signature

12-7-31

300

Identify as per dwg & Stock Location: 46

0.00

300

Packaging

Packaging

Memo

0.00

Packaging

Signature

12-7-31

(2)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

July-12-12 10:00:11 AM

Item ID: D2966-1-BENT

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Assembly 105

Start Date: 12/07/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

310

QC

Memo

0.00

Quality Control

12/8/12
MW 12107131

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

July-12-12 10:00:16 AM

Page 1

Work Order ID: 87800

87800

Parent Item: D2966-1-BENT

D2966-1-BENT

Parent Item Name: Skidtube Assembly 105

Start Date: 12/07/2012

Required Date: 17/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.09.17 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2962-125

Manufactured

No

D2962-125

Outer Tube Extrusion

D 2962-150

Each

15.0000

**

1
DC 12 / 07 / 31

B 28672

Location

Loc Qty

Loc Code

HALL

17532

15

15

①

①

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00 05 11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21800 M.C.S.
12/07/12

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART
QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)



01.01.29
(P 01.01.30)

AZ	02.10.30	ADD D3176-1/-3	# UP
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	# UP

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

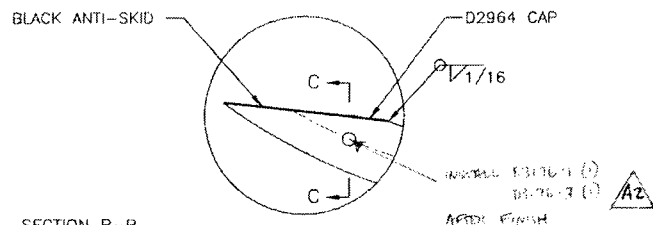
DQA: _____ Date: _____

QA Closed: _____ Date: _____

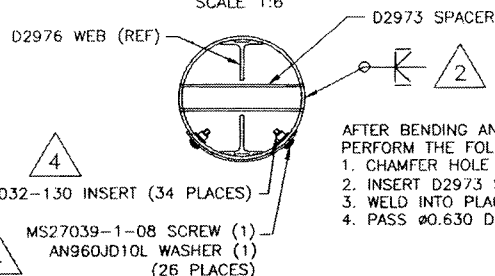
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY											
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27800

DETAIL A
SCALE 1:3

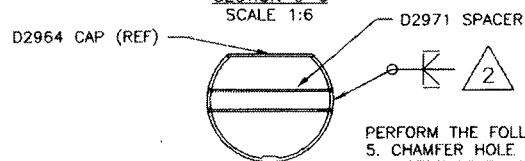


SECTION B-B
SCALE 1:6



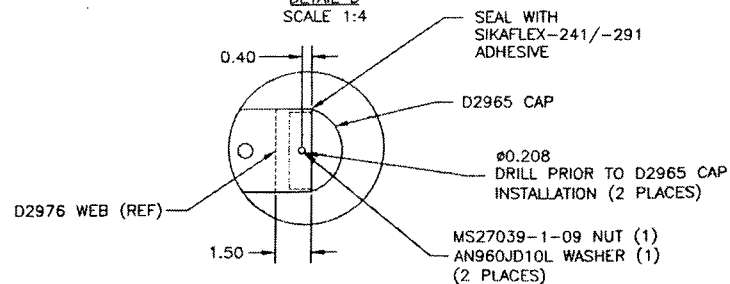
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2973 SPACER (7 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 1:6

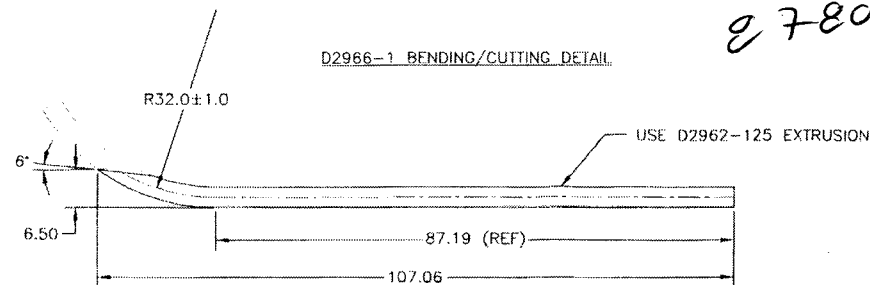


PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:
5. CHAMFER HOLE $0.030 \times 45^\circ$
6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

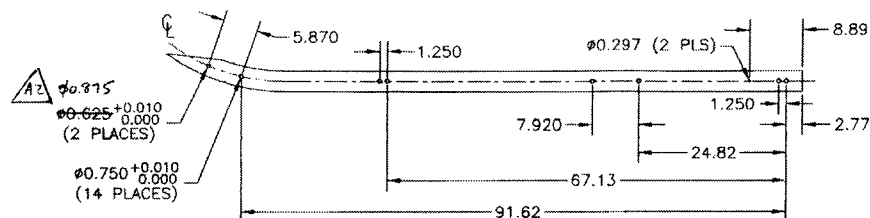
DETAIL D
SCALE 1:4



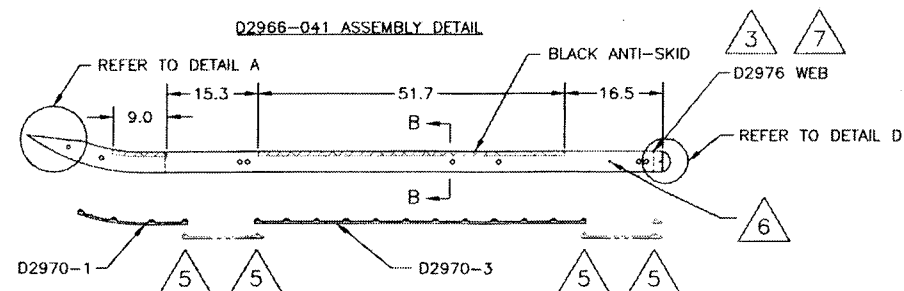
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED A	APPROVED A	DRAWING NO. D2966
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY		REV. A SHEET 2 OF 2 SCALE 1:20

RELEASED

NCR: Yes / No

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